



**Work Order ID 57263**

Monday, September 13, 2010 8:43:00 AM



Page 2

Item ID: D3589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/09/21

(4)

130



Small Fab

Small Fab

Memo

1- Assemble as per dwg

0.00

0.00

E 5/10/09/21 (4)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/09/21

(4)

**Work Order ID 57263**

Monday, September 13, 2010 8:43:00 AM



Page 3

Item ID: D3589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *68*

0.00



Packaging

Memo

0.00

Packaging

*10/9/21 sf*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/09/21*  
*MF*  
*10-9-21*

# Picklist Print

Monday, September 13, 2010 8:43:00 AM

Page 1

Work Order ID: 57263

Parent Item: D3589-041

Parent Item Name: LATCH ASSEMBLY



Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise process as per coss DD 10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD4 Washer	NAS1149DN432J	Purchased	No			130	Each	1,140.000	4	16		9/5/10/09/21	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST346				1140					
					11735			709					
					7636			431					
D3589-1 ARM		Manufactured	No			100	Each	6.0000	1	4		EL 10-9-14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					56926			6					
D3589-11 FWD GUIDE PLATE		Manufactured	No			100	Each	16.0000	1	4		EL 10-9-13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				16					
					56928			16					
D3589-13 LUG		Manufactured	No			100	Each	20.0000	2	8		EL 10-9-13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				20					
					56929			20					

# Picklist Print

Monday, September 13, 2010 8:43:00 AM

Page 2

Work Order ID: 57263

Parent Item: D3589-041

Parent Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

D3589-15  
LINK  
Manufactured No

130 J Each

13.0000

2

8

Location

Loc Qty

Loc Code

WA

13

56930

13

D3589-3  
ARM GUIDE  
Manufactured No

100 Each

24.0000

4

16

Location

Loc Qty

Loc Code

WA

24

56931

4

57377

20

D3589-7  
AFT GUIDE PLATE  
Manufactured No

100 Each

16.0000

1

4

Location

Loc Qty

Loc Code

ST072

16

56932

16

D3589-9  
FWD GUIDE PLATE  
Manufactured No

100 Each

9.0000

1

4

Location

Loc Qty

Loc Code

WA

9

56933

9

MS20392-1C7  
Pin  
Purchased No

130 J Each

30.0000

2

8

Location

Loc Qty

Loc Code

ST315

30

108521

30

Monday, September 13, 2010 8:43:00 AM

Shop Packet Print

Page 2

# Picklist Print

Monday, September 13, 2010 8:43:00 AM

Page 3

Work Order ID: 57263



Parent Item: D3589-041



Parent Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

MS24665-1010

Purchased

No

130 3

Each

201.0000

2

8



COTTER PIN



*Ep 10/08/21*  
8

Location

Loc Qty

Loc Code

ST309

201

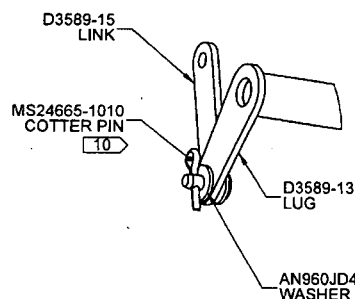
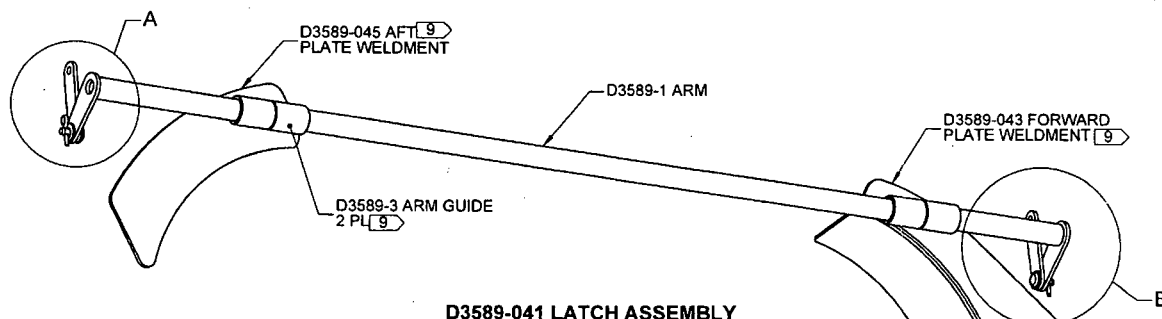
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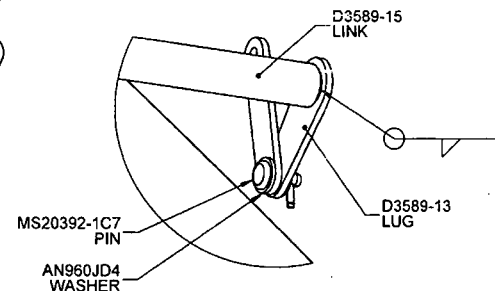
114405

189

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



**DETAIL A: LINK ASSEMBLY DETAIL**  
SCALE 2X  
2 PL



**DETAIL B: WELDING AND LINK ASSEMBLY DETAIL**  
SCALE 2X  
2 PL

**RELEASED**  
9/16/05

B	0.80 AND 0.83 REF WERE 1.97 AND 0.80 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.86 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

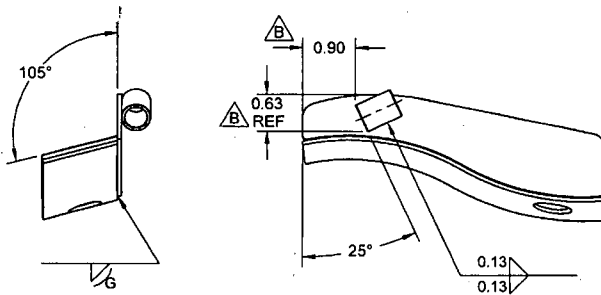
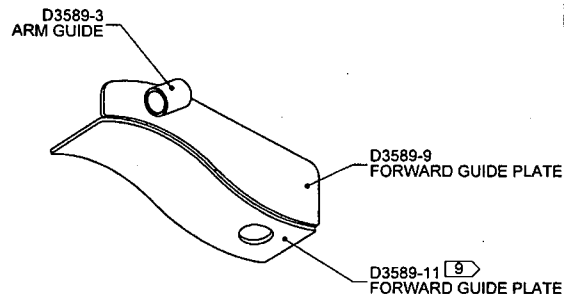
- D3589-041 NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs
  - 8) WELDING: PER DART QSI 004 USING DT9033
  - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
  - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

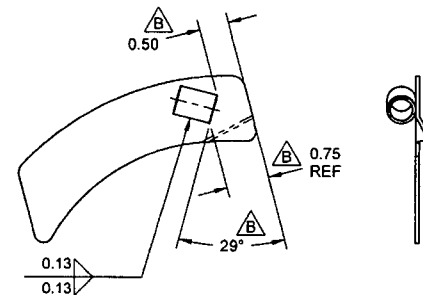
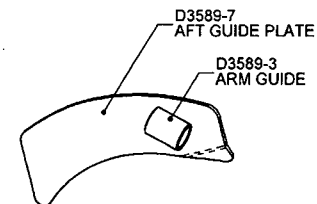
DRAWING NO. **D3589** REV. B  
SHEET 1 OF 8  
TITLE **LATCH ASSEMBLY** SCALE NTS

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QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

**D3589-043/-045 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D3589-043 = 0.22 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

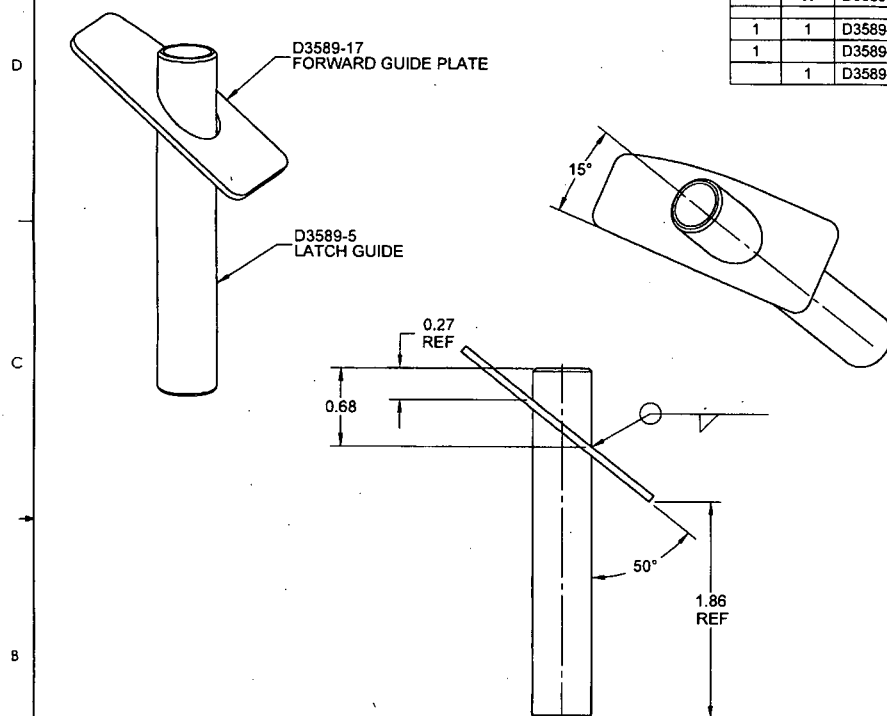
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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**RELEASED**  
29/07/25 N/A

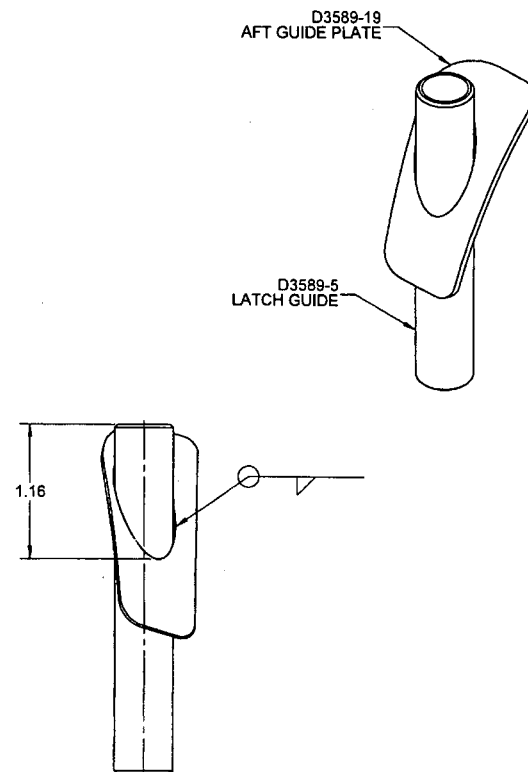
57263



QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



**D3589-047 FORWARD GUIDE**



**D3589-049 AFT GUIDE**

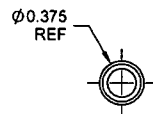
**D3589-047/-049 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

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**RELEASED**  
9/10/05

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MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.			NTS
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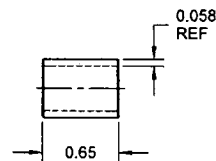
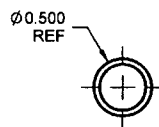


0.03 X 45°  
CHAMFER  
2 PL

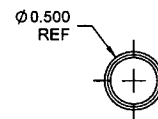


0.065  
REF

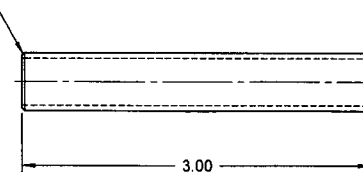
**D3589-1 ARM**



**D3589-3 ARM GUIDE**



0.03 X 45°  
CHAMFER  
2 PL



0.049  
REF

**D3589-5 LATCH GUIDE**

**D3589-1/-3/-5 NOTES:**

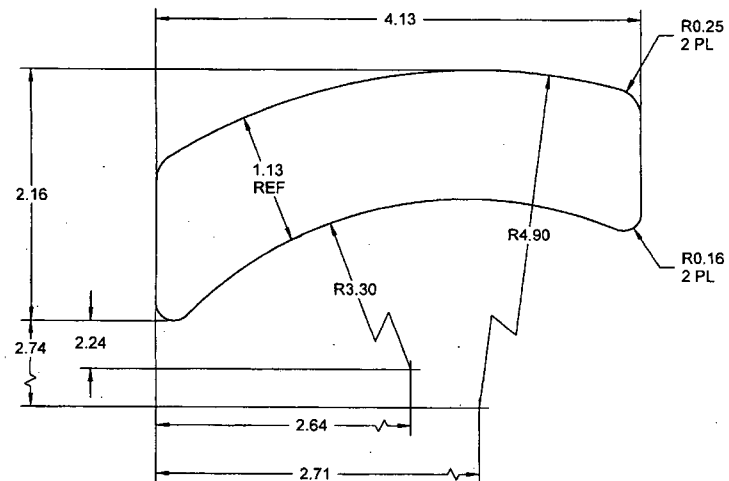
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
- D3589-3 = 0.01 lbs  
- D3589-5 = 0.06 lbs

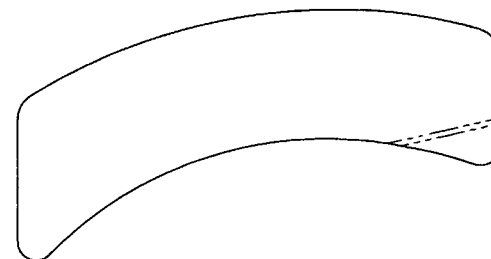
**RELEASED**  
9/6/25

57263

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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**D3589-7F AFT GUIDE PLATE  
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE  
MAKE FROM D3589-7F**

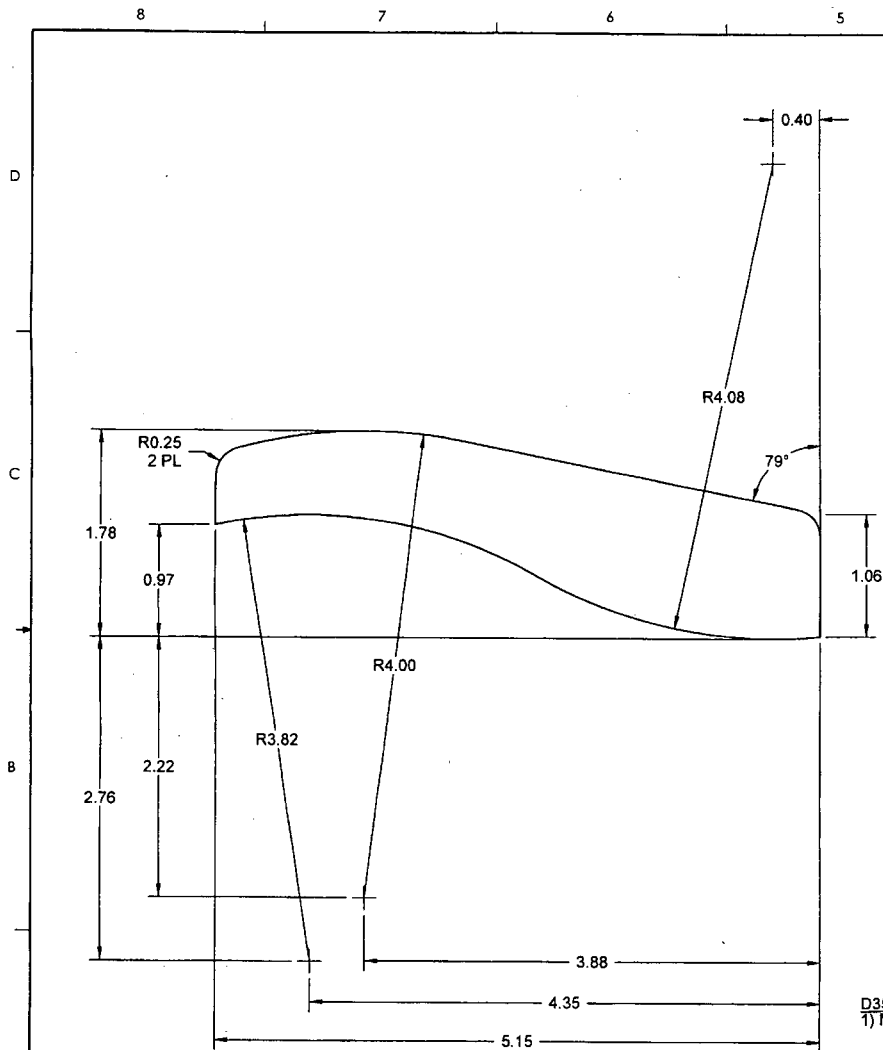
**RELEASED**  
09/22/55 N/A

**D3589-7F NOTES:**

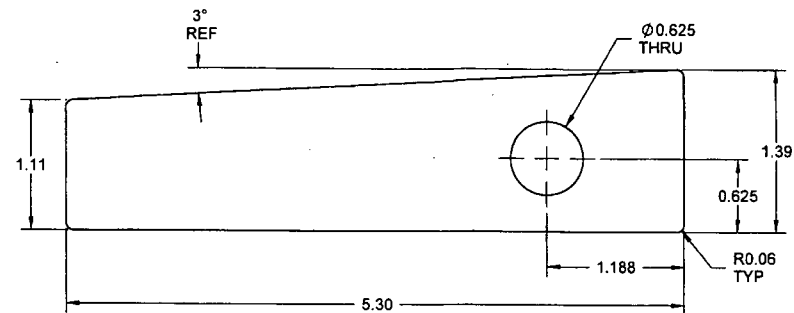
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

57263

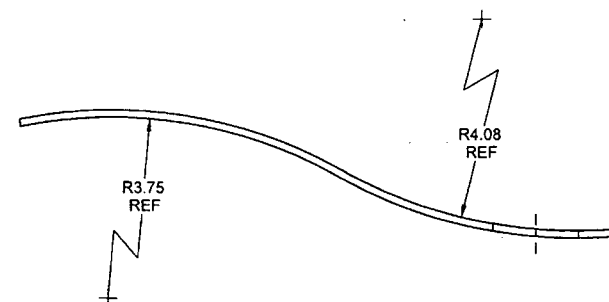
DESIGN	J	<b>DART AEROSPACE LTD</b>	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	JS	D3589	SHEET 5 OF 8
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**D3589-9 FORWARD GUIDE PLATE**  $\triangle$  B



**D3589-11F FORWARD GUIDE PLATE**  
**FLAT PATTERN**  $\triangle$  B



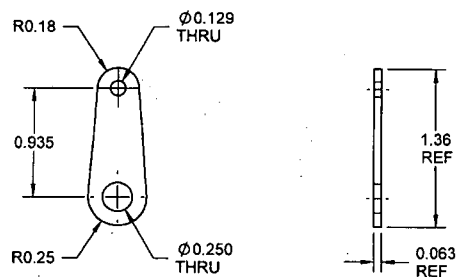
**D3589-11 FORWARD GUIDE PLATE**  
(MAKE FROM D3589-11F)

- D3589-9/-11/-11F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.09 lbs EACH
  - 8) CONTROL SHAPE PER DT9021 TEMPLATE

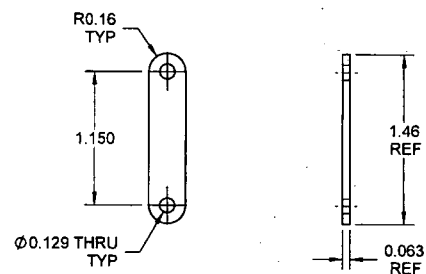
57263

**RELEASED**  
09/26/2014

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
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**D3589-13 LUG**



**D3589-15 LINK**

**D3589-13/-15 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

57263

**RELEASED**  
07/02/05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3589</b>	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>LATCH ASSEMBLY</b>	NTS
DATE	<b>08.06.25</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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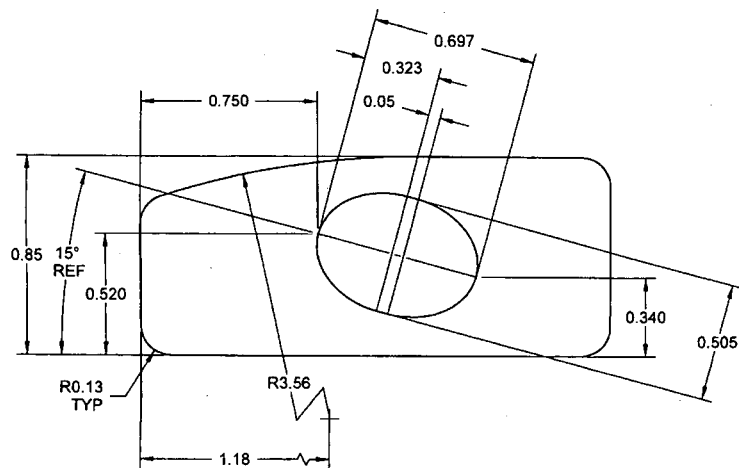
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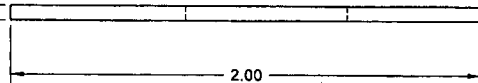
C

B

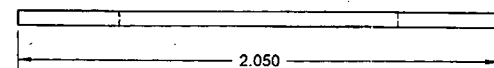
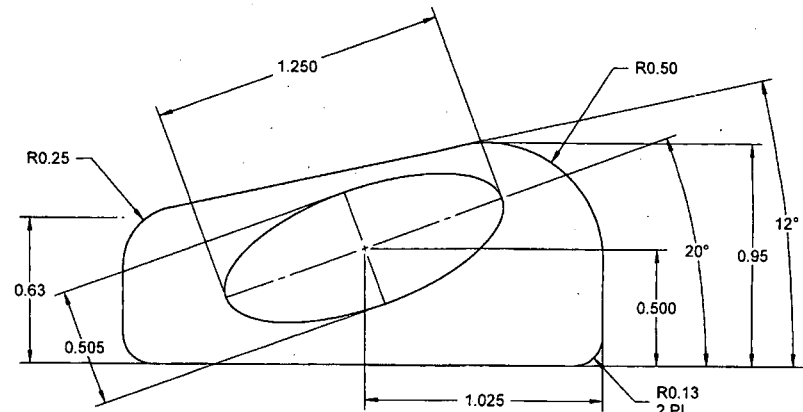
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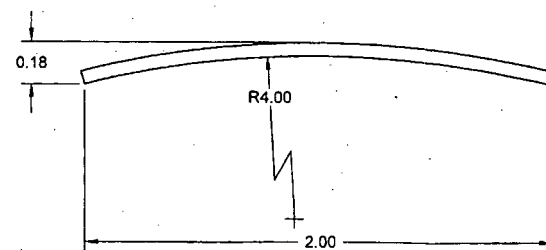
0.063  
REF



**D3589-17 FORWARD GUIDE PLATE**



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE**  
(MAKE FROM D3589-19F)

**RELEASED**  
09/23/05/11/17

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

57263

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OF THE EXPRESS OR IMPLIED CONTENTS OF THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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